

B3
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surface of said green tire corresponding to said lug grooves such that the carved grooves extend in substantially the same direction as said lug grooves and that each of the carved grooves has substantially a triangular shape widening gradually from a side of a tread center to a side of a tread end

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14. (Amended) A method for manufacturing a pneumatic tire as claimed in claim 13, wherein expansion rate of said belt member is 3% or less.

15. (Amended) A method for manufacturing a pneumatic tire as claimed in claim 1, wherein a full-mold vulcanization-molding machine having an upper mold and a lower mold is used as a mold for vulcanizing and molding said green tire.

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17. (Amended) A method for manufacturing a pneumatic tire, comprising:
a step of manufacturing a green tire in which extruded rubber having the shape of a ribbon or a sheet is piled up on a ply and a belt member assembled on a drum to form a tread;
a step of forming a carved groove on a tread surface of said green tire in direction of a lug groove; and

B5 307 a step of charging said green tire formed with said carved groove in a vulcanization-molding machine to carry out vulcanization-molding so as to form a vulcanized tire having the lug groove.

Please add the following new claim:

B5 307 --19. (New) A method as claimed in claim 1, wherein said triangular shape is formed by the step of carving a first groove extending in a direction inclined to an axis of the tire and a second groove extending substantially in parallel with said axis and partly overlapping said first groove.--